

# Work Order ID 71295

Monday, June 27, 2011 11:46:12 AM



Page 1

Item ID: D3999-5

Accept



Setup Start



Revision ID:

Stop



Item Name: Angle

Start Date: 6/27/2011 Start Qty: 10.00



Cust Item ID:

Required Date: 6/28/2011 Req'd Qty: 10.00

Customer:

Reference:

Approvals:

Process Plan: *W*

Date:

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/  
Work Center ID

Operation  
Description

Set Up/  
Run Hours

Tool ID

Tool #

Plan  
Code

Accept  
Qty

Reject  
Qty

Reject  
Number

Insp.  
Stamp

Draw Nbr

Revision Nbr

D3999

A

100

0.00



Waterjet

Memo

0.00

FLOW CNC Waterjet

1-Cut as per Dwg

Dwg Rev: *A*

Prog Rev: *A*

2-Deburr if necessary

*HB11-6-27*



110

QC2- Inspect parts off machine FAI/FAIB

0.00



QC

Memo

0.00

Quality Control

*HB11-6-27*

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Required Date: 6/28/2011 Req'd Qty: 10.00



Customer:

Reference:

Run Start



Approvals:

Process Plan:

Date:

Tooling:

Date:

Stop



QC:

Date:

SPC (Y/N):

Date:

Sequence ID/  
Work Center ID

Operation  
Description

Set Up/  
Run Hours

Tool ID

Tool #

Plan  
Code

Accept  
Qty

Reject  
Qty

Reject  
Number

Insp.  
Stamp

120

QC8- Inspect parts - second check

0.00



QC

Memo

0.00

Quality Control

8 11/06/27

(+12)

130

Bend as per dwg

0.00



Brake NC

Memo

0.00

Brake NC

SB 11/06/27

(12)

150

Chemical Conversion Coat per QSI005 4.1

0.00



HandFinish

Memo

0.00

Hand Finishing

12 ~~BL H-6~~  
M. J. 11/06/27

**Work Order ID 71295**

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Setup Start



Revision ID:

Stop



Item Name: Angle

Start Date: 6/27/2011 Start Qty: 10.00



Cust Item ID:

Required Date: 6/28/2011 Req'd Qty: 10.00



Customer:

Reference:

Run Start



Approvals: Process Plan: Date: Tooling: Date:

Stop



QC: Date: SPC (Y/N): Date:

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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160

QC5- Inspect part completeness to step on W/O.

0.00



QC

Memo

0.00

Quality Control

8 w/loc/28

(13)

170

Identify as per dwg &amp; Stock Location: 104

0.00



Packaging

Memo

0.00

Packaging

6/28/11 (13)

180

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

11/6/28 JF

11-06-28 (13)

# Picklist Print

Monday, June 27, 2011 11:46:09 AM

Page 1

Work Order ID: 71295



Parent Item: D3999-5



Parent Item Name: Angle

Start Date: 6/27/2011

Required Date: 6/28/2011

Start Qty: 10.00

Required Qty: 10.00

Comments: IPP rev A 09.12.16 new issue Prelim EC verified by:DD IPP rev B  
10.05.10 ecn 10-562 EC verified by:DD

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M6061T6S.040		Purchased	No			100	sf	106.5000	0.048	0.505263			



6061-T6 .040 Sheet

B11-6-27

Location

Loc Qty

Loc Code

MAT021

106.5

113004

10.5

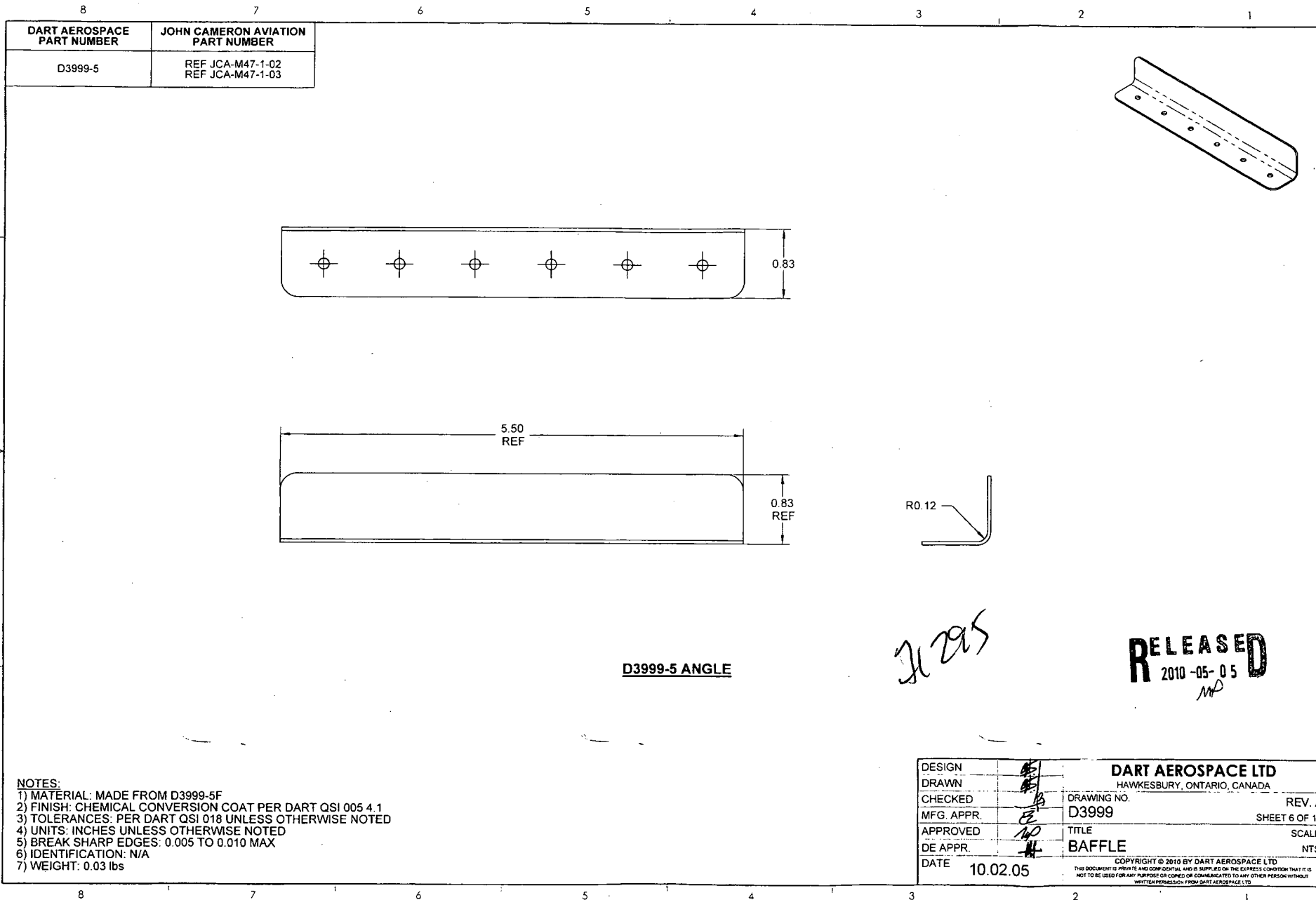
117653

96

113004

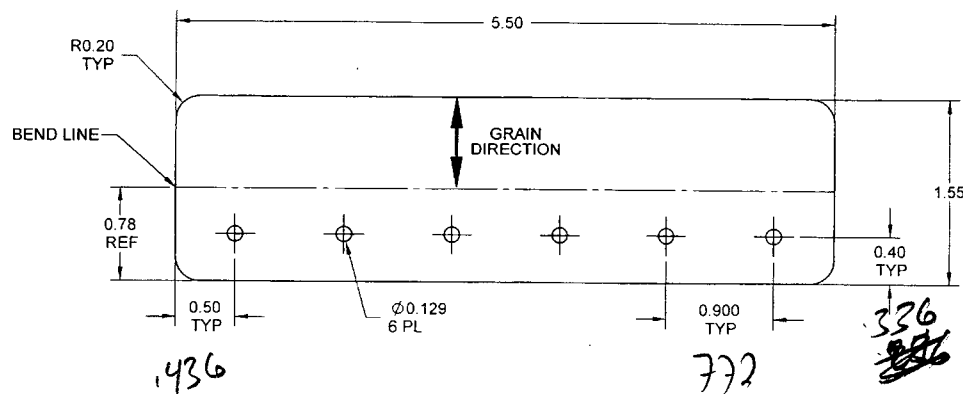
(12)





**NOTES:**

- 1) MATERIAL: MADE FROM D3999-5F
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 0.03 lbs



**D3999-5F FLAT PATTERN**

**NOTES:**

- 1) MATERIAL: 6061-T6 (OR 6061-T62) ALUMINUM SHEET, 0.040 THICK  
PER AMS-QQ-A-250/11 OR AMS 4025 OR AMS 4027  
REF DART SPEC M6061T6S.040
- 2) FINISH: N/A
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 0.03 lbs

DESIGN		<b>DART AEROSPACE LTD</b>	
DRAWN		HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. A
MFG. APPR.		D3999	SHEET 7 OF 12
APPROVED		TITLE	SCALE
DE APPR.		BAFFLE	NTS
DATE	10.02.05	<small>COPYRIGHT © 2010 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COMMERCE TIED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.</small>	

**RELEASED**  
2010-05-05  
JMP